

Date: Wednesday, 13/02/2008 1:18:36 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: ANGLE		
Job Number	: 37400			Part Number	: D37411		
Estimate Number	: 13168			Drawing Number	: D3741 U/R		
P.O. Number	:			Project Number	: N/A		
This Issue	: 13/02/2008	S.O. No.	:	Drawing Revision	: U/R		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 13/02/2008		
Previous Run	: 37307			Qty:	10	Um:	Each
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev:A 08-01-30 new issue DD verified by:						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6207	Angle Extrusion 1x1x.125	
		Comment: Qty.: 0.0656 f(s)/Unit Total : 0.6563 f(s) D6207 angle extrusion Batch: <del>112707</del> B37538 B27538	
2.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: 1- Mill as per dwg D3741	
	2-Deburr		20 08/02/14
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	20 08/02/14 (10)
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	31 08/02/14
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	18 08.02.14 10
		1- Grind radius as per dwg D3741	19 08.02.14 10
		2- Deburr if necessary	20 08.02.14 10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08. 02. 14	5b.	add 2 Steps, Alodine Step and inspection Step after Step 5 permanent change	SAL	08.02.14		/	/	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

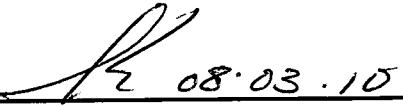
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 13/02/2008 1:18:37 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services	Drawing Name: ANGLE
Job Number: 37400	Part Number: D37411
Job Number:	

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP 
		 08/03/10 (10)
Comment: INSPECT WORK TO CURRENT STEP		
7.0	PACKAGING 1	PACKAGING RESOURCE #1 
		 08/03/10 (10)
Comment: PACKAGING RESOURCE #1		
	Identify and Stock Location: U/A	 08.03.10
8.0	QC21	FINAL INSPECTION/W/O RELEASE 
		 08/03/17 (10)
Comment: FINAL INSPECTION/W/O RELEASE		

Job Completion



08.02.27

POSITIVE RECALL  
EXECTIVE 08.02.13 AUTH LL  
RELEASED LLS DATE 08.03.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description:	Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## **First Article      Prototype**

Measured by:	<i>RQ</i>	Audited by:		Prototype Approval:	
Date:	<i>08/02/14</i>	Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

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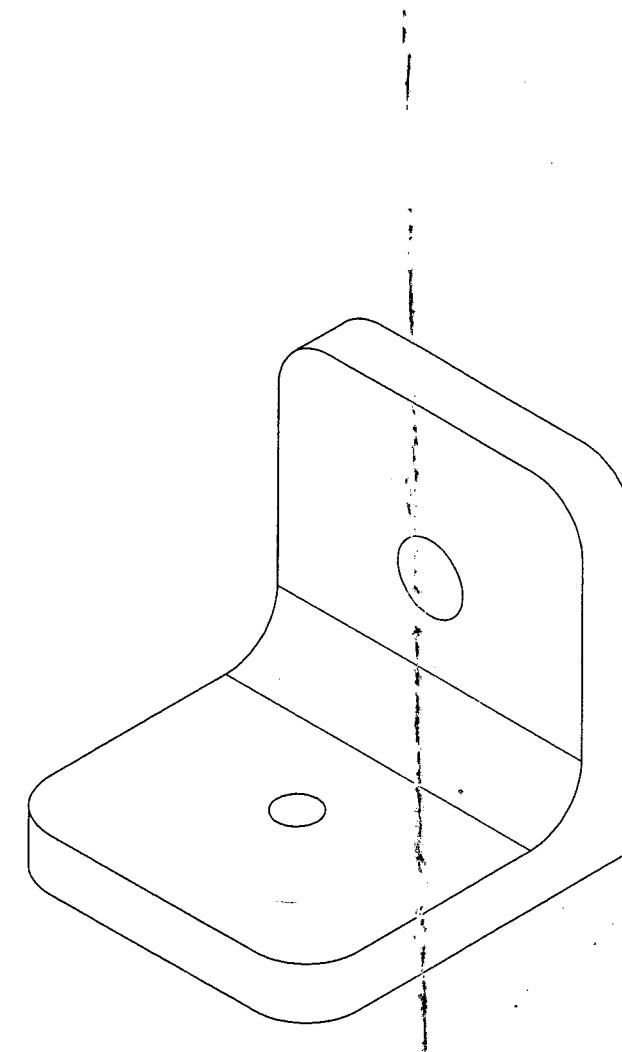
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**PRELIMINARY ISSUE**

NOT A  
Good IDEA

- NOTES:  
1) MATERIAL: MAKE FROM D6207 OR D6203 EXTRUSION  
2) FINISH: ~~None~~ Chemical Conversion Coat.  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.01 lbs

A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.		D3741	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ANGLE	NTS
DATE	08.02.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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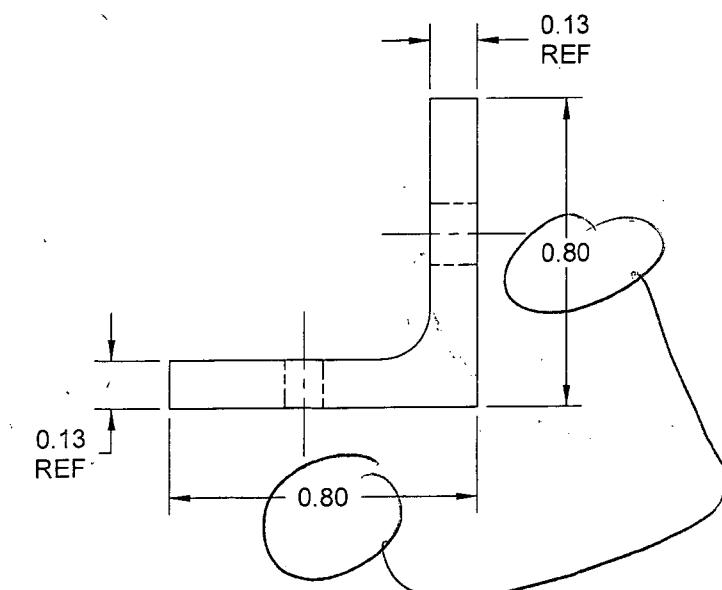
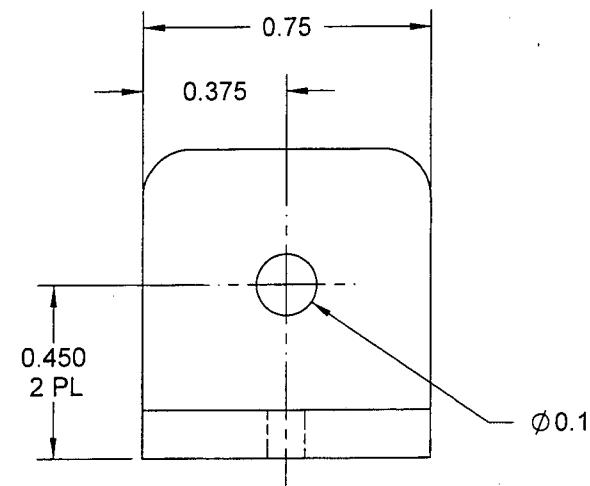
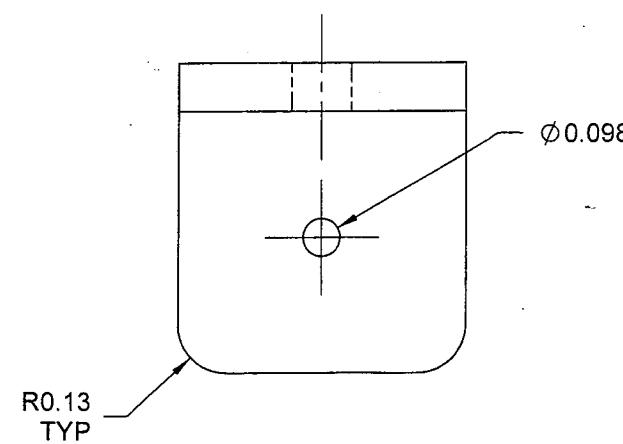
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**PRELIMINARY ISSUE**

COSTLY TO  
DRAW AN  
ANGLE ISN'T IT?

DESIGN	AJS	<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	UC	DRAWING NO.
MFG. APPR.		D3741
APPROVED		REV. A
DE APPR.		SHEET 2 OF 2
DATE	08.02.04	SCALE
		2:1
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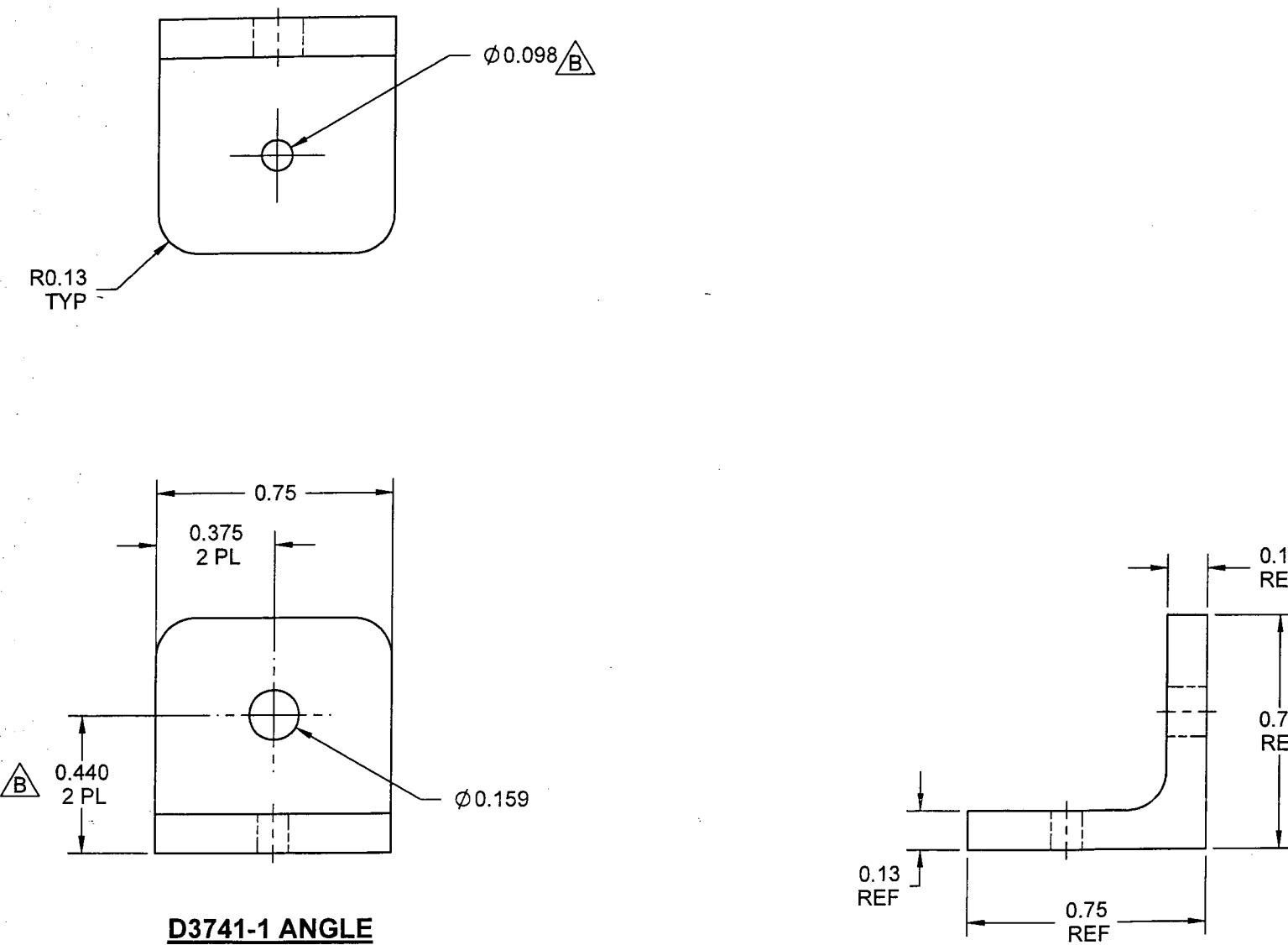
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DESIGN	AJS	<b>DART AEROSPACE LTD</b>
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>CE</i>	DRAWING NO.
MFG. APPR.	<i>BD</i>	<b>D3741</b>
APPROVED	<i>MP</i>	REV. B
DE APPR.	<i>CH</i>	SHEET 2 OF 2
DATE	08.03.06	TITLE
		ANGLE
		SCALE
		NTS

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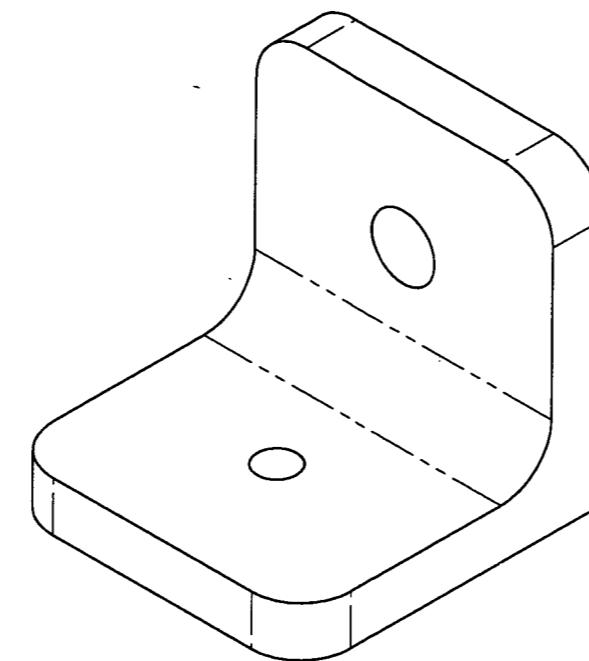
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**D3741-1 ANGLE** ▲B

**NOTES:**

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.125 PER AMS-QQ-A-200/8  
(REF. DART SPEC. M6061T6A750XW125) ▲B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

B	SHEET 1 NOTES DART SPEC IN MATERIALS UPDATED, ISO VIEW UPDATED SHEET 2 ZONE D5, Ø0.098 HOLE WAS Ø0.159, ZONE 6B Ø.440 DIM WAS 0.450.	AJS	08.03.06
A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CE	DRAWING NO.	REV. B
MFG. APPR.	NS	D3741	SHEET 1 OF 2
APPROVED	MO	TITLE	SCALE
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